

Work Order ID 86960

86960

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July-09-12 3:01:06 PM

Item ID: D2163

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Console Trim Angle

Start Date: 7/09/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2163

Rev B

10

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2163 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

5052.050

B12-7-05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-7-05

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00 SymB
12-7-05

DAS
12-7-05

Quality Control

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2163 Accept *N900040100* Setup Start *NS1*
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 Item Name: Console Trim Angle
 Start Date: 7/09/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:50								
	FINISH TIME: 1:20								
W 121279	3200F								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 006	0.00							
180									
Packaging	Memo	0.00							
Packaging									

10X 12/08/23

102 4 12/08/23

5/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCS 12/08/24

CMF
12-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July-09-12 3:01:05 PM

Page 1

Work Order ID: 86960

Parent Item: D2163

Parent Item Name: Console Trim Angle

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: F02.05.11Clarify IPP NG
IPP Rev:G 07-11-08 Now On Waterjet JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.050 5052-H32 .050 Sheet		Purchased	No			110	sf	226.0000	0.0694	0.4383156	1.		

B12-9-25

Location	Loc Qty	Loc Code
MAT022	226	
115389	64	
116268	64	
118654	64	
14050	2	
4894	32	

116268

(10)

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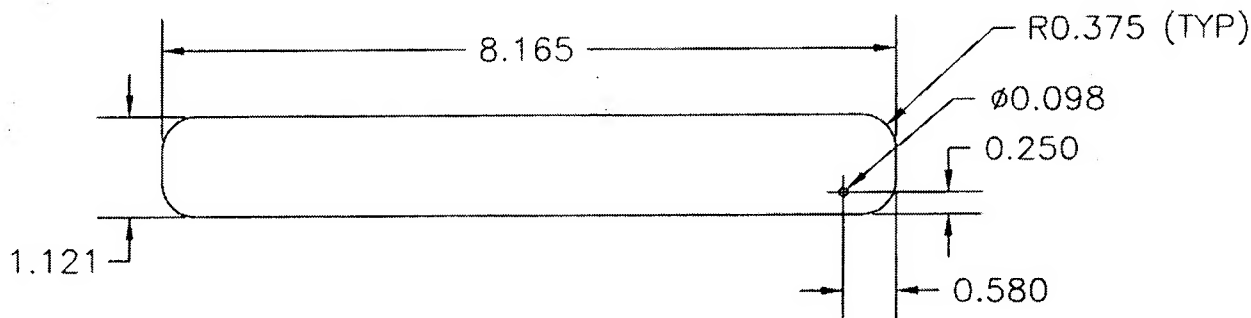
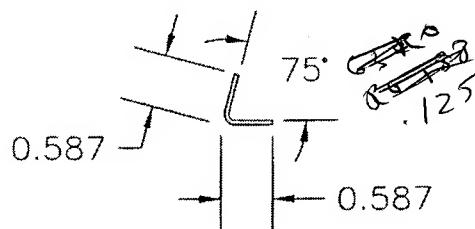
DART



RELEASED
97.11.04 KE
TSR A421

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86960 MJS

12/07/10



MATERIAL: 5052-H32 (QQ-A-250/8) 0.050 THICK
FINISH: POWER COAT MATTE BLACK PER DART QSI 005 4.3

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	<i>KE</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2163
DATE	97.10.30	TITLE	TRIM ANGLE	REV. B	SHEET 1 OF 1
A	95.05.19	RE-DRAWN	REMOVE BEND DATA	SCALE	1:2
B	97.10.30				

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